

Date: Tuesday, 15/07/2008 4:12:01 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 40516	
Estimate Number : 10533	
P.O. Number :	Part Number : D2573
This Issue : 15/07/2008 S.O. No. :	Drawing Number : D2573 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 40198	Material :
Written By :	Due Date : 08/08/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08.7.16</u>	
Comment : Est. I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2573
 Ensure that grain is along 7.75" length
 Batch No: B34875

mk 08/08/18

18

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 40576 Double check by: H.A

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

mk J.F. 08/08/20

⑩

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

mk J.F. 08/08/20

⑩

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk J.F. 08/08/20

⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:12:02 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 40516

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/08/20

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m2/m/08/08/20

(X10)

7.0

POWDER COATING

POWDER COATING



M108523



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*9-20
320 °F
9-50*

m. 08/08/21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT

08.08-21

(2X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SI 443

C 08/08/21

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



mf 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 40516
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.499	3.500		
D	1.745	1.755		1.750	1.749	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.503	.502	.502	.504		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.501	.500	.500		
J	1.174	1.184		1.179	1.181	1.179	1.179		
K	0.558	0.578		.566	.566	.569	.567		
L	1.174	1.184		1.179	1.181	1.179	1.179		
M	1.365	1.375		1.368	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.500	2.500	2.499		
O	4.119	4.129		4.124	4.123	4.125	4.125		
P	0.115	0.135		.126	.126	.127	.126		
Q	0.115	0.135		.135	.135	.135	.125		
R	0.240	0.260		.249	.252	.252	.251		
S	0.115	0.135		.121	.120	.120	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.230	3.230	3.236		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.122	.123	.122	.121		
X	0.308	0.313		.310	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.766		
Z	0.352	0.372		.359	.365	.367	.363		
AA	0.470	0.530		.506	.500	.500	.500		
AB	0.615	0.635		.631	.634	.635	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.244	.245	.244		
AE	1.500	1.520		1.512	1.512	1.514	1.513		
AF	0.115	0.135		.127	.127	.127	.130		
AG	0.240	0.280		.268	.265	.262	.261		
AH	0.240	0.260		.249	.251	.250	.250		
AI	2.000	2.020		2.000	2.000	2.003	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	08/08/18

Audited by:	<i>[Signature]</i>
Date:	08/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 40514
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.440	0.439"	0.439"	0.439"		
B	1.745	1.755		1.750	1.750"	1.750"	1.750"		
C	3.495	3.505		3.500	3.501"	3.501"	3.501"		
D	1.745	1.755		1.750	1.750"	1.750"	1.750"		
E	7.990	8.010		8.000	8.004"	8.004"	8.004"		
F	0.490	0.510		.507	.504"	.507"	.509"		
G	0.257	0.262		.260	.260	.260	0.257"		
H	0.375	0.380		.378	.378	.378	0.377"		
I	0.490	0.510		.501	.501	.500	.501"		
J	1.174	1.184		1.180	1.179	1.179	1.179"		
K	0.558	0.578		.565	.566	.567	.571"		
L	1.174	1.184		1.180	1.179	1.179	1.179"		
M	1.365	1.375		1.368	1.370	1.370	1.370"		
N	2.495	2.505		2.499	2.499	2.500	2.500"		
O	4.119	4.129		4.125	4.126	4.125	4.125"		
P	0.115	0.135		.127	.127	.127	.126"		
Q	0.115	0.135		.135	.135	.135	.120"		
R	0.240	0.260		.251	.251	.252	.250"		
S	0.115	0.135		.115	.119	.120	.125"		
T	0.178	0.198		.188	.188	.188	.188"		
U	3.210	3.250		3.230	3.228	3.229	3.230"		
V	0.230	0.250		.240	.240	.240	.239"		
W	0.115	0.135		.123	.120	.121	.125"		
X	0.308	0.313		.310	.311"	.311"	.311"		
Y	0.760	0.765		.761	.760"	.760"	.761"		
Z	0.352	0.372		.365	.364"	.362"	.369"		
AA	0.470	0.530		.500	.500	.500	R.500"		
AB	0.615	0.635		.635	.635"	.634"	.634"		
AC	0.053	0.073		.063	.063	.063	.063"		
AD	0.240	0.260		.241	.242	.246	.250"		
AE	1.500	1.520		1.513	1.513	1.515	1.513"		
AF	0.115	0.135		.131	.125	.127	.135"		
AG	0.240	0.280		.265	.265	.265	.273"		
AH	0.240	0.260		.249	.248	.248	.251"		
AI	2.000	2.020		2.002	2.002	2.004	2.002"		
AJ	0.023	0.043		.033"	.033"	.033"	.033"		
Accept/Reject									

Measured by: JML / J.F.
Date: 08/08/18

Audited by: J.S.
Date: 08/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 40516
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3	4		
A	0.438	0.443		0.439"	0.439"				
B	1.745	1.755		1.750"	1.750"				
C	3.495	3.505		3.501"	3.501"				
D	1.745	1.755		1.750"	1.750"				
E	7.990	8.010		8.005"	8.005"				
F	0.490	0.510		0.507"	0.508"				
G	0.257	0.262		0.258"	0.258"				
H	0.375	0.380		0.377"	0.377"				
I	0.490	0.510		0.502"	0.506"				
J	1.174	1.184		1.179"	1.179"				
K	0.558	0.578		0.567"	0.570"				
L	1.174	1.184		1.179"	1.179"				
M	1.365	1.375		1.370"	1.370"				
N	2.495	2.505		2.500"	2.500"				
O	4.119	4.129		4.125"	4.125"				
P	0.115	0.135		0.126"	0.124"				
Q	0.115	0.135		0.130"	0.130"				
R	0.240	0.260		0.251"	0.250"				
S	0.115	0.135		0.120"	0.124"				
T	0.178	0.198		0.188"	0.188"				
U	3.210	3.250		3.230"	3.230"				
V	0.230	0.250		0.239"	0.238"				
W	0.115	0.135		0.124"	0.125"				
X	0.308	0.313		0.312"	0.311"				
Y	0.760	0.765		0.761"	0.761"				
Z	0.352	0.372		0.370"	0.370"				
AA	0.470	0.530		0.500"	0.500"				
AB	0.615	0.635		0.635"	0.630"				
AC	0.053	0.073		0.063"	0.063"				
AD	0.240	0.260		0.250"	0.250"				
AE	1.500	1.520		1.513"	1.512"				
AF	0.115	0.135		0.135"	0.135"				
AG	0.240	0.280		0.273"	0.273"				
AH	0.240	0.260		0.251"	0.251"				
AI	2.000	2.020		2.003"	2.002"				
AJ	0.023	0.043		0.033"	0.033"				
Accept/Reject									

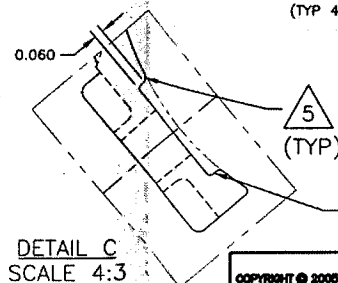
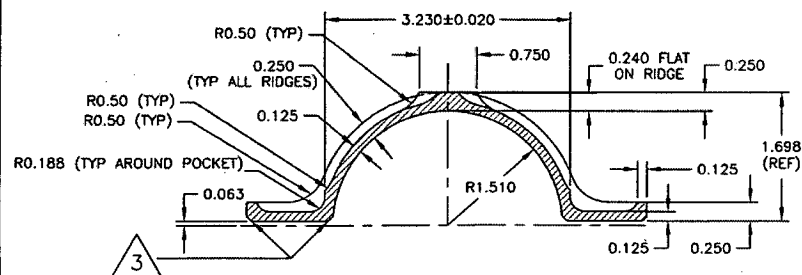
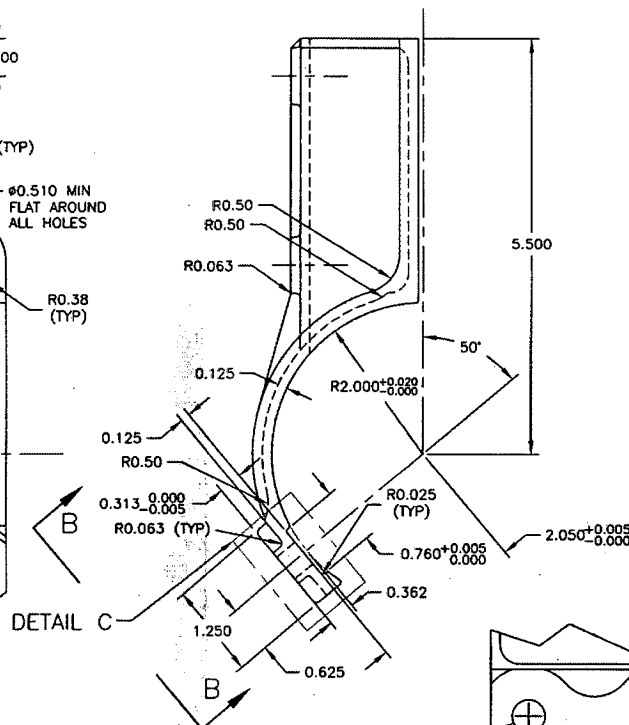
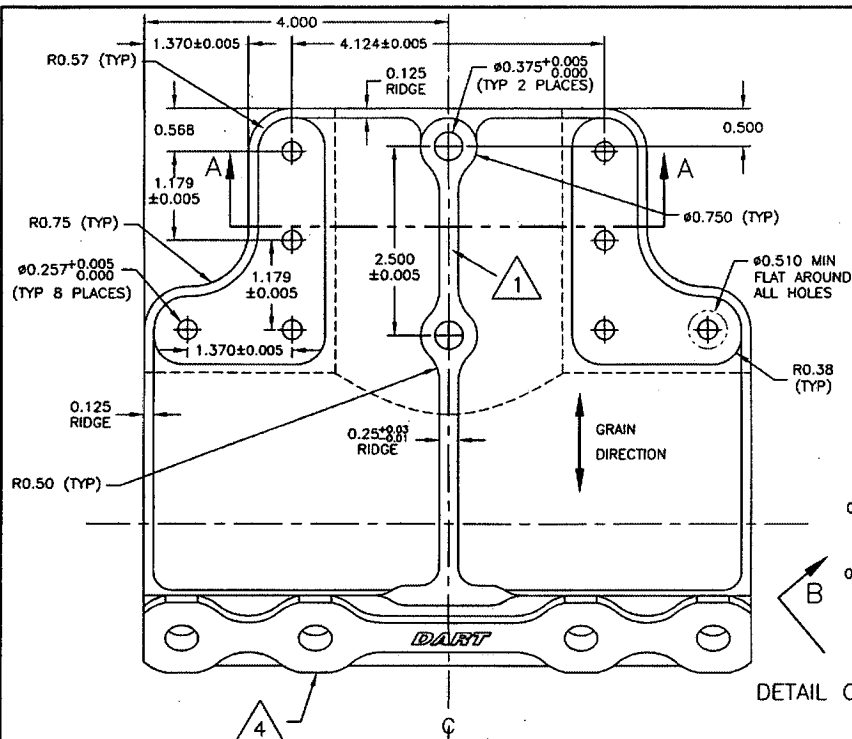
Measured by: JF
Date: 08/08/20

Audited by: [Signature]
Date: 08/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

RELEASED

05.12.06

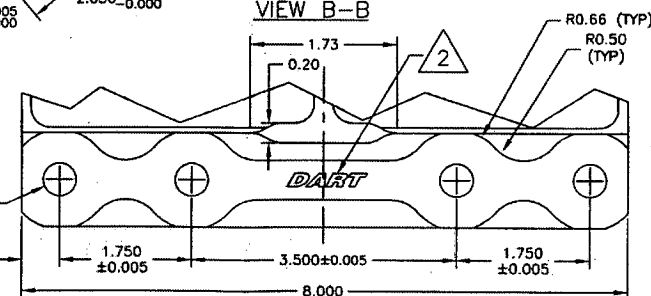


NOTES

MATERIAL: 7075-T7351 (00-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD.
CHECKED	#	APPROVED	#	DRAWING NO.	D2573
DATE	05.07.13	TITLE	OUTER AFT SADDLE	REV. E	SHEET 1 OF 1
		SCALE	2:3		

NO. 40574
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY